DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027857
Date Inspected: 26-Jun-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Job site

CWI Name:	N/A			**CWI Present:**	☑ Yes	☐ No		
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: Tower

Summary of Items Observed:

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QAI was provided ABF QC reports to verify, utilizing ultrasonic testing for the Tower Shear Plate weld connections designated as ESW “T” and ESW “L”. The weld has been previously repaired and tested by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.4 and supplemental contract document SE-UT-D1.5-CT-108-ESW. The QA was informed previously that transverse indications were observed in repair excavations on similar Electro slag welds (ESW) on earlier dates and that scanning pattern “E” will need to be utilized in order to detect these indications. Due to the presence of weld reinforcement the QAI was unable to size the length and measure the “X” location on the welds in way of the suspected transverse indications. Discrepancies were discovered on the QC report by the QAI and not reported and or miss-reported on QC UT report provided.

The following suspected transverse indications detected ultrasonically on this date are neither rejectable nor recordable in accordance with AWS D1.5-2002, section 6, table 6.4, however some were observed to exhibit planar characteristics.

Face A Weld ESW “T” (Y=6440 ~ Y=9000)
Y=6450, Sound Path=124, Depth=40, AWS db Rating = +13
Y=6640, Sound Path=105, Depth=34, AWS db Rating = +17

Y=6680, Sound Path=112, Depth=36, AWS db Rating = +21
Y=6730, Sound Path=110, Depth=35, AWS db Rating = +14
Y=6810, Sound Path=106, Depth=34, AWS db Rating = +7
Y=6900, Sound Path=140, Depth=45, AWS db Rating = +18
Y=6930, Sound Path=123, Depth=40, AWS db Rating = +15
Y=7210, Sound Path=123, Depth=40, AWS db Rating = +20
Y=7400, Sound Path=153, Depth=49, AWS db Rating = +15
Y=7615, Sound Path=117, Depth=38, AWS db Rating = +18
Y=7710, Sound Path=125, Depth=40, AWS db Rating = +20
Y=7300, Sound Path=97, Depth=31, AWS db Rating = +23
Y=7950, Sound Path=96, Depth=31, AWS db Rating = +21
Y=8000, Sound Path=106, Depth=34, AWS db Rating = +17
Y=8055, Sound Path=98, Depth=31, AWS db Rating = +9
Y=8075, Sound Path=119, Depth=38, AWS db Rating = +13
Y=8265, Sound Path=140, Depth=48, AWS db Rating = +22
Y=8500, Sound Path=124, Depth=40, AWS db Rating = +21
Y=8675, Sound Path=144, Depth=46, AWS db Rating = +16
Y=8700, Sound Path=94, Depth=30, AWS db Rating = +12
Y=8840, Sound Path=111, Depth=36, AWS db Rating = +17
Y=9000, Sound Path=91, Depth=29, AWS db Rating = +16

Face A Weld ESW “L” (Y=0 ~ Y=2300)
Y=130, Sound Path=100, Depth=32, AWS db Rating = +7
Y=410, Sound Path75, Depth=25, AWS db Rating = +17
Y=765, Sound Path=101, Depth=32, AWS db Rating = +15
Y=780, Sound Path=126, Depth=41, AWS db Rating = +17
Y=870, Sound Path=107, Depth=34, AWS db Rating = +19
Y=1290, Sound Path=117, Depth=33, AWS db Rating = +20
Y=1445, Sound Path=85, Depth=27, AWS db Rating = +22
Y=1710, Sound Path=88, Depth=28, AWS db Rating = +17
Y=1920, Sound Path=74, Depth=24, AWS db Rating = +21
Y=2090, Sound Path=80, Depth=26, AWS db Rating = +16
Y=2160, Sound Path=121, Depth=29, AWS db Rating = +20

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer